

Wednesday, 5/16/2007 8:13:15 AM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32373  
Estimate Number : 11057  
O. Number : N/A  
His Issue : 5/16/2007 S.O. No. : N/A  
Rshf Rev. : NC Type : PURCHASED PARTS  
First Issue : N/A  
Previous Run : 29108  
Written By : John 05/16  
Checked & Approved By :  
Comment : Est. C 02.11.26 Added P/O KJ

Drawing Name : 02.250 SUPPORT

Part Number : D28911  
Drawing Number : D2891 REV A1  
Project Number : N/A  
Drawing Revision : A1  
Material : N/A  
Due Date : 6/5/2007

Qty: 1 Um: Each

Split

## Additional Product

Job Number:



Description:

Seq. #: Machine Or Operation:

PURCHASING

1.0 PG



Comment: PURCHASING

Issue P/O: 379520705117

(16)

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

17-4 SS Roundbar 3.25"OD

2.0 D6104003



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Support 2.25 dia

PACKAGING RESOURCE #1

3.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

MORI SEIKI CNC LATHE LARQE

John 06/05 (6)

4.0 MORI SEIKI



Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

INSPECT ALL DIM TO DIM SHEET

JL 8.801/06/07

5.0 QC1



Comment: INSPECT ALL DIM TO DIM SHEET

JL 8.807/06/07

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## Process Sheet

Drawing Name: 02.250 SUPPORT

Job Number: 32373

Part Number: D28911

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

J.F. 07/06/27

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/06/27

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

9.0 SPRAY PAINTING

SPRAY PAINTING

Comment: SPRAY PAINTING

P10:4058 07/06/27 (2)

-PRIME

- PAINT DELFLEET BLUE

-CLEAR DELFLEET

10.0 QC14

INSPECT SPRAY PAINT

07-07-03 (2)



Comment: INSPECT SPRAY PAINT

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: cross lake

Ep 07/07/04

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



07/07/04

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
Lathe Section										
A	2.274	2.279		2.275	2.275	2.278	2.277			
B	3.702	3.722		3.680	3.712	3.712	3.710			
C	2.564	2.584		2.574	2.574	2.574	2.574			
D	0.718	0.738		.733	.730	.730	.730			
E	0.090	0.110		.087	.090	.090	.090			
F	2.464	2.484		2.474	2.474	2.474	2.474			
G	2.029	2.049		2.032	2.032	2.032	2.032			
H	2.964	2.984		2.974	2.974	2.974	2.972			
I	0.913	0.933		.918	.919	.919	.919			
J	0.022	0.042		.032	.032	.032	.032			
K	0.090	0.110		.099	.099	.099	.098			
L										
HAAS Section										
AA	0.188	0.193	DT8706							
AB	0.240	0.260								
AC	0.115	0.150								
AD	0.040	0.060								
AE	0.010	0.020								
AF	0.240	0.260								
AG	0.290	0.310								
AH	0.115	0.150								
AI	0.454	0.474								
AJ	2.779	2.789								
AK	0.240	0.260								
AL	1.002	1.042								
AM	0.053	0.073								
AN	0.257	0.262	DT8683							
AO	1.663	1.683								
AP	0.053	0.073								
AQ	0.022	0.042								
AR										
AS										
Accept/Reject										

Measured by:	3.61	/	J.F.	Audited by:	SA
Date:	07/06/07	/	07/06/07	Date:	07.06.07

Rev	Date	Change	Revised by	Approved
A	07.12.12	New Issue	YUPE	YUPE